



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBA9829-A-PO
Job Sheet 193586



Part No: RBA9829-A-PO

Job Qty: 2 pcs

Part Name: Main Rotor Mast Nut Wrench (RB Design)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 5/14/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBA9829-A Rev. 4 IPP Rev. A 18.08.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	2 pcs	5/14/19	5/14/19	0.00	0.00	Purchasing - 1	DP MAY 16 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	5/14/19	5/14/19	0.00	0.00	Packaging 2 - 1 - B4B	DP MAY 16 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Container No: S181978



Part: RBA9829 - A

Job No: 193586

Serial No/Batch: S181978

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/16/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	2 pcs	5/14/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
150	Packaging 3-1 - Stock - B4B	2 pcs	5/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160	QC 21 - FG	2 pcs	5/14/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

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MAY 16 2019

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MAY 22 2019

Part Op 100 - (Purchasing) Issue PO to ARROW TECH MACHINE WORKS P/O: 043227 MANUFACTURE RBA9829-A AS
 Descriptions: PER DWG -Certificate of conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

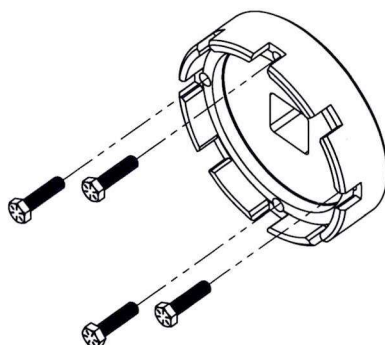
x1 Plus 16 APR 2019.

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBA9829-AP	Main Rotor Mast Nut Wrench (RB Design)	2 Ea (1 ea)	100-Purchasing	5181974
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBA9829-AP	2	0	0
Part Specifications				
Specifications could not be found.				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		INSIDE DIA. INCREASED FROM $\varnothing 2.575$ TO $\varnothing 2.625$ DEPTH INCREASED FROM .540 TO .590. CORNER RADIUS LIMIT OF .015, THICKNESS AT MAX O.D. INCREASED FROM .712 TO .912. BOLD CHANGED FROM AN3-5A TO AN3-6A	3/16/05	-	-
2		CHANGED -3 BOLT FROM AN3-6A TO AN3-4A, AND DELETED -5 WASHERS AN960-10L.	9/27/06	-	-
3		CHANGED -3 BOLT FROM AN3-4A TO AN3-6A, ALSO ADDED NEW DWG FORMAT.	7/3/08	WP	DW
4	16-0080	UPDATED TO NEW STANDARD. -1 CH'D MAT'L WAS 4140 IS 4140/4142. ADDED 3/4 DRIVE DIMS. CH'D DIM WAS R.125 IS R.13. CH'D DIM WAS .10 CHAMFER IS .10 X 45°. CH'D DIM WAS .045 CHAMFER EACH INSIDE CORNER IS 16X .045 X 45°. REMOVED NOTE DRILL 13/16 PILOT FOR 3/4 BROACH. ADDED SPEC QMSI-6.2.2 REV D.	7/21/2016	DEW	SM



NOTE:
BOLTS DO NOT PROTRUDE THRU NUT WHEN INSTALLED.

DART AEROSPACE	
TITLE ROTOR MAST NUT WRENCH	
DWG NO. RBA9829-A	REV 4
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT T&T	.XX $\pm .005$ FRACTIONS $\pm 1/8$
FINISH X	.X $\pm .01$ ANGLES $\pm 5^\circ$
SPEC	.X $\pm .1$ SURFACES = 125
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.6M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	MD 500
SCALE 1:2	DATE 10/10/2000 SHEET 1 OF 2

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	WRENCH	4140/4142		2
		B/O	-3	4	BOLT	STEEL	AN3-6A	1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO043227



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: PO043227

PO Date: 4/16/19

Due Date: 5/14/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pynt Terms: Net 30

Freight Terms:

Special Comments:

MAY 14 2019

E-MAILED

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	193586	RBA9829-AP			Main Rotor Mast Nut Wrench (RB Design)	Firmed X2	-	5/14/19	2 Ea	0 Ea	2 Ea	\$613.00/Ea	\$1,226.00

MAY 16 2019

Grand Total: \$1,226.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 556

Date: 5/10/19
PO Ref: 043236
PO Ref: 042227
Ship vi Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
4	T/R DAMPER LENGTH ADJUSTMENT	RBW6405G00531-3G
2	ROTOR MAST NUT WRENCH	RBA9829-A

RECEIVED
MAY 16 2019
DART AEROSPACE LTD.

Received by: _____

Packaged by: JA _____

Checked by: JA _____

Thank You



ARROW TECHMACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 43227 Dated: 5/10/19

Our Order/ Job No: AWT-43227 Order Qty: 2

Part Name: ROTOR MAST NUT WRENCH

Part Number RBA9829-A

Lot Size: N/ A Ship Date: 5/10/19

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBA9829-A Rev:4

Material Size and Type: 3.50" ROUND BAR 4140/4142

Material Specifications: ASTM A108

Heat Treatment: RC 37-38

Plating/ Finish : N/ A

Mercury Contamination : The material used to process this order has not come in contact with mercury or mercury bearing instruments.

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Date: 5/10/19

Signature: [Signature] I I C 11.11.11 7"

PHGE Machine Works LLC dba Arrow Tech Machine Works
297 51 E. Enid Rd. Unit C Eugene, Oregon 97402
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www.atechmachinesworks.com